

Work Order ID 78325***78325***

Page 2

January-05-12 10:03:08 AM

Item ID: D4095-047

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearpad Assembly

Start Date: 1/05/12 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/13/12 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Form as per dwg
NC BRAKE

0.00

130

Brake NC

Memo

0.00

Sn 12/01/05

(12)

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Sn 12/01/05

(12)

Quality Control

150

Weld per dwg A/R Hardcoat S.S. Batch: ~~1120028~~

0.00

150

Large Fab

Large Fab

Memo

m120028

0.00

X/2 12-01-06 JBL

Large Fab

Work Order ID 78325

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78325

Page 3

Item ID: D4095-047 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearpad Assembly
 Start Date: 1/05/12 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 1/13/12 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
180 *180* HandFinish Hand Finishing	COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG A/R ROCKGUARD BATCH: <u>119947</u>	0.00 0.00							

12 . 01 . 09 (12)

Work Order ID 78325

78325

Page 4

January-05-12 10:03:08 AM

Item ID: D4095-047 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearpad Assembly
 Start Date: 1/05/12 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 1/13/12 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00		8/17/01/07		(42)			
Quality Control									

200	Identify as per dwg & Stock Location: <u>FP-2</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									

112 4 14 12/01/09
 COUNTER & MEASURED.

210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

12/11/10

12-01-10

Picklist Print

January-05-12 10:03:08 AM

Page 1

Work Order ID: 78325

Parent Item: D4095-047

Parent Item Name: Wearpad Assembly

Start Date: 1/05/12

Required Date: 1/13/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev.A 11.11.07 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

sf

101.8300

0.882

304/316 Sheet .063

IB 12-1-5

Location

Loc Qty

Loc Code

MAT020

101.83

119346

32

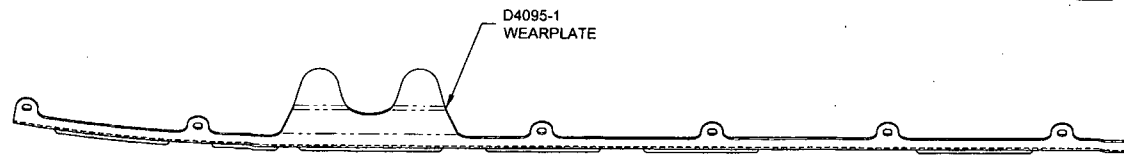
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69.83

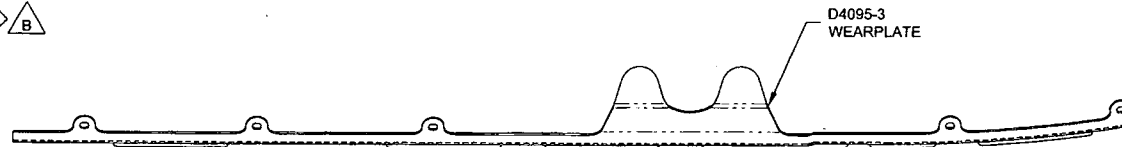
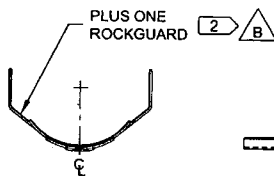
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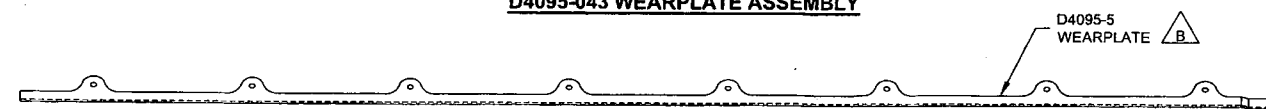
ITEM	QTY	QTY	QTY	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
1	X							D4095-041	WEARPLATE ASSEMBLY
2		X						D4095-043	WEARPLATE ASSEMBLY
3			X					D4095-045	WEARPLATE ASSEMBLY
4				X				D4095-047	WEARPAD ASSEMBLY
5					X			D4095-049	WEARPAD ASSEMBLY
6						X		D4095-051	WEARPAD ASSEMBLY
7	1							D4095-1	WEARPLATE
8		1						D4095-3	WEARPLATE
9			1					D4095-5	WEARPLATE
10				1				D4095-7	WEARPAD
11					1			D4095-9	WEARPAD
12						1		D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)



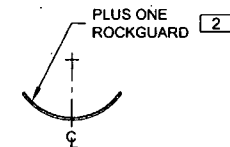
D4095-041 WEARPLATE ASSEMBLY



D4095-043 WEARPLATE ASSEMBLY



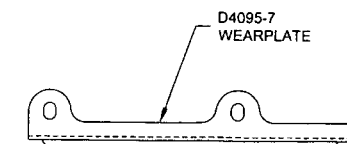
D4095-045 WEARPLATE ASSEMBLY



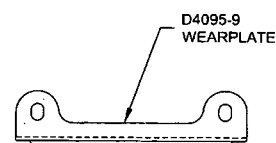
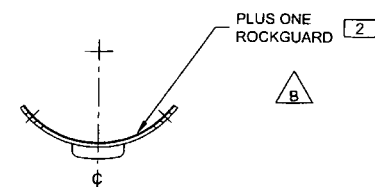
D4095-041/-043/-045/-047/-049/-051 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

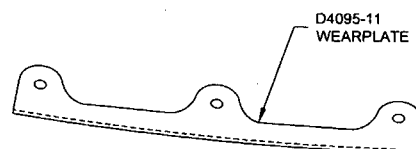
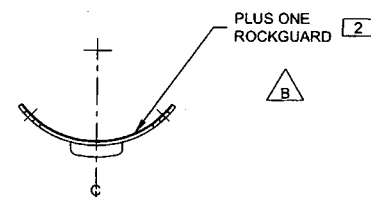
B	REVISED D4095-1A-1F/3/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4096-1A-3; ADDED D4095-5I-7 -9I-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED	AP		
MFG. APPR.	AP		
APPROVED	AP		
DE APPR.	AP		
DATE	11.10.18		
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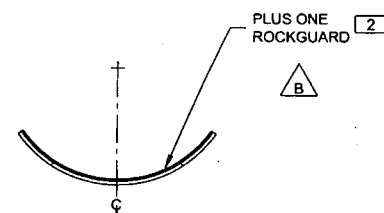
D4095-047 WEAR PAD ASSEMBLY



D4095-049 WEAR PAD ASSEMBLY

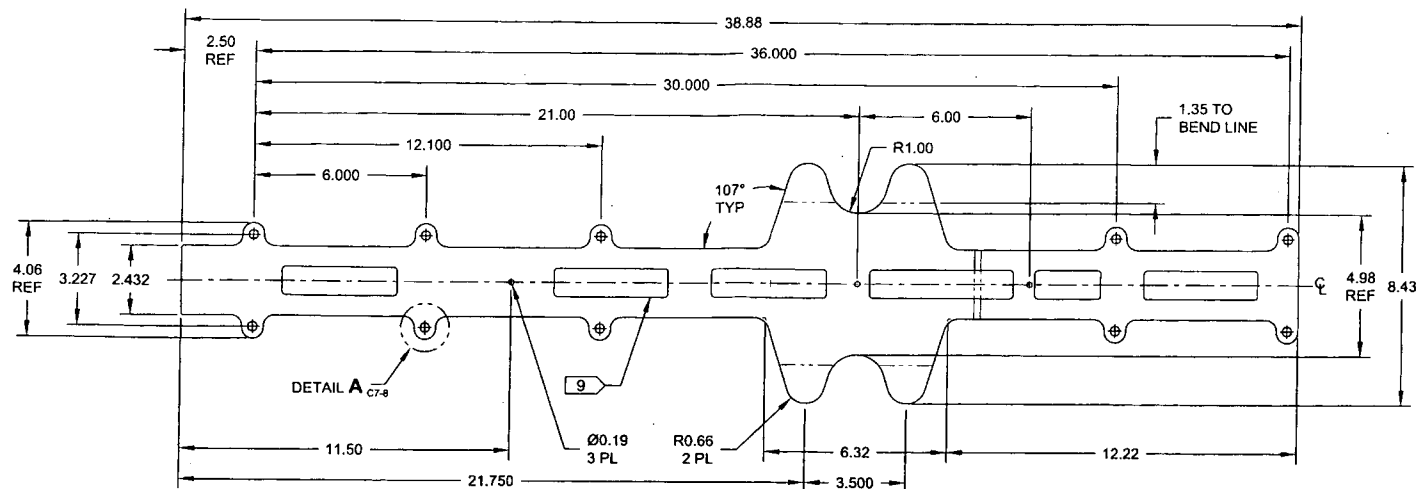


D4095-051 WEARPAD ASSEMBLY

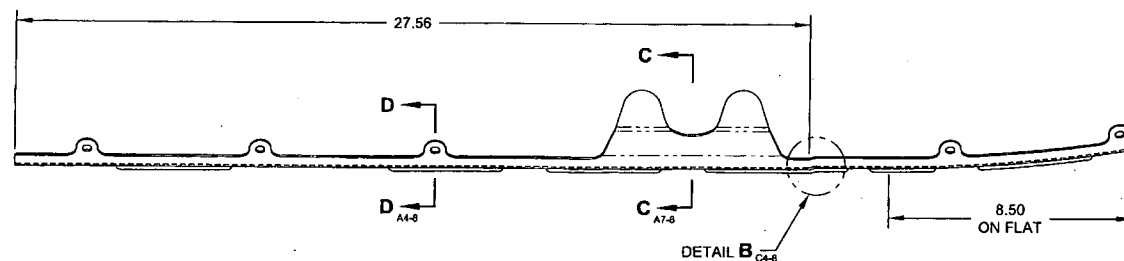


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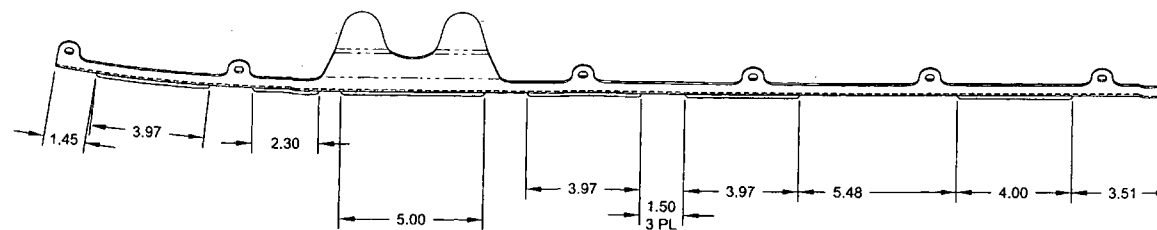
D4095-3F FLAT PATTERN 1



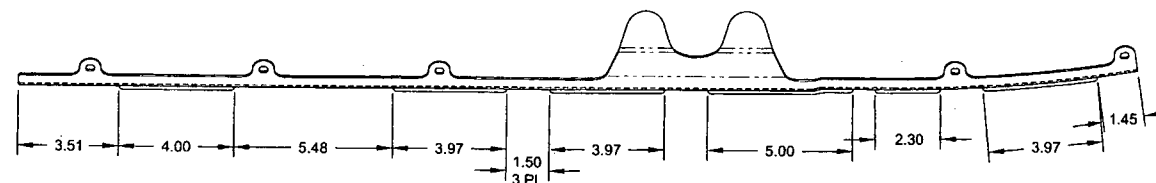
D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

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D4095-1 WELDING DETAIL

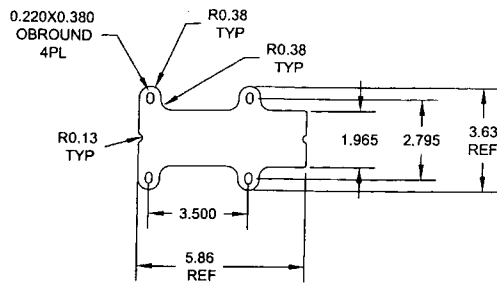


D4095-3 WELDING DETAIL

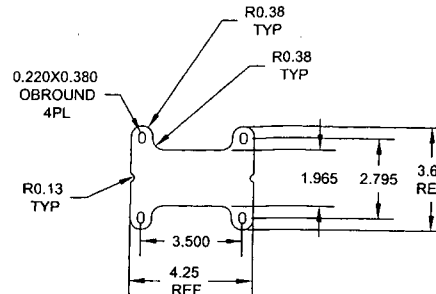


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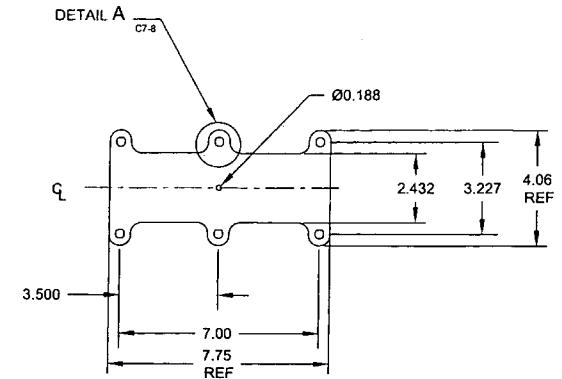
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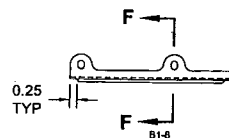
D4095-7F FLAT PATTERN 1



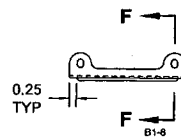
D4095-9F FLAT PATTERN 1



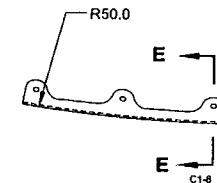
D4095-11F FLAT PATTERN 1



D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)



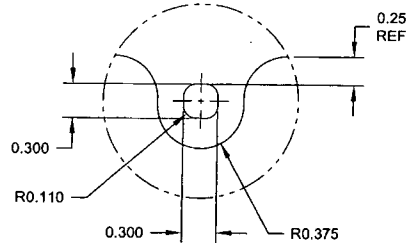
D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)



D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

2011-10-31

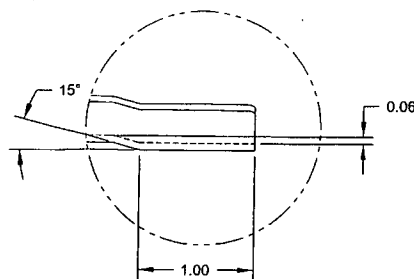
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DETAIL A: TAB DETAIL

SCALE 4X

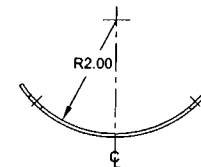
C3-3
C6-4
D3-6
D2-7



DETAIL B: JOGGLE DETAIL

SCALE 4X

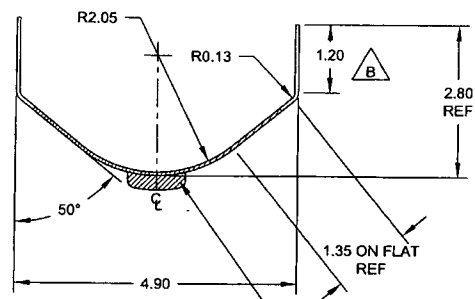
B2-3
B6-3
B3-1
B2-6



SECTION E-E

SCALE 2X

B5-6
B2-7

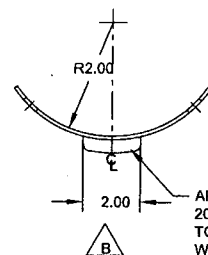


SECTION C-C

SCALE 2X

B5-3
B4-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

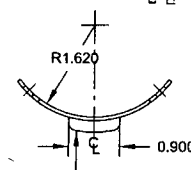


SECTION D-D

SCALE 2X

B4-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F

SCALE 2X

B5-7
B7-7

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

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2011-10-31

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